



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4669-1

Job Sheet 185420



Part No: D4669-1

Job Qty: 20 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEETS 1,2 IPP REV:A 12.07.26 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	20 pcs		11/23/18	0.00	0.62	Waterjet - Flow		SL 18/10/29
120	QC	20 pcs		11/23/18	0.00	0.00	QC8		38
130	Brake NC	20 pcs		11/23/18	0.01	3.63	Brake NC 1		SL DAS 38
140	QC	20 pcs		11/23/18	0.00	0.00	QC5		38
150	HandFinish	20 pcs		11/23/18	0.00	0.38	HandFinish1		DR 18/12/4
160	QC	20 pcs		11/23/18	0.00	0.00	QC7-4		Smb
170	Packaging	20 pcs		11/23/18	0.00	0.00	Packaging3-2		Smb
180	QC21-SA	20 Ea		11/23/18	0.00	0.00	QC21		DAS 21 DEC 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.032	6061-T6 Sheet 0.032"	1.0540 sf (.0527 ea)	100-Waterjet	5018006

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.032	1	145	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.098Inches + 0.004 - 0.001	0.102 0.097	0.099	Diameter
2	Bracket	0.640Inches ± 0.030	0.670 0.610	0.638	
3	Bracket	0.940Inches ± 0.030	0.970 0.910	0.939	
4	Bracket	1.160Inches ± 0.030	1.190 1.130	1.162	
5	Bracket	2.320Inches ± 0.030	2.350 2.290	2.324	
6	Bracket	2.840Inches ± 0.030	2.870 2.810	2.845	
7	Bracket	3.480Inches ± 0.030	3.510	3.486	

QA Closed: _____ Date: _____

Work Order update only



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																																																																																			
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐																																																																																																																																																													
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐																																																																																																																																																													
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐																																																																																																																																																													
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐																																																																																																																																																															
Date :		Step #:		QTY Effective :						MRB (QSI042) Approval																																																																																																																																																													
Description Work Order Deviation																																																																																																																																																																							
Container No: S122232 Part: D4669-1 Job No: 185420 Serial No/Batch: S122232 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/29/18  Completed By _____ / Supervisor Verification Coordinator Approval Dart Aerospace Ltd. 1270 Aberdeen Street Hewesbury, ON K6A 1K7 CANADA TEL: 1 613 832-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																																																																																																																							
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			3.450	
8	Bracket	2.540Inches ± 0.030	2.570 2.510	2,538
9	Bracket	1.320Inches ± 0.010	1.330 1.310	1,317
10	Bracket	0.440Inches ± 0.010	0.450 0.430	0,442
11	Bracket	0.220Inches ± 0.010	0.230 0.210	0,221
12	Bracket	0.032Inches ± 0.010	0.042 0.022	0,030
13	Bracket	0.320Inches ± 0.030	0.350 0.290	0,322
14	Bracket	1.520Inches ± 0.030	1.550 1.490	1,519
15	Bracket	1.840Inches ± 0.030	1.870 1.810	1,837
16	Bracket	2.180Inches ± 0.030	2.210 2.150	2,178

Plex 10/26/18 7:43 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					